

**Garant**
**Solid carbide HPC drill type FS plain shank DIN 6535 HA, TiAlN, Ø DC h7:  
18,06-Xmm**

**Order data**

Order number	122670 18,06-X
GTIN	4062406079055
Item class	11E

**Description**
**Version:**

**Particularly strong** due to strengthened core and **special profile**. Special point geometry.  
**High concentricity** and **long tool life**.

**High bore quality**.

**Note:**

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122675**.

Form **HE**: order with **No. 122670 + 129100HE**. Delivery time: 12 working weeks

Minimum order quantity: 3 pcs

Items made to order for a specific customer:

Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement.

Items cannot be returned. We reserve the right to over-deliver or under-deliver by  $\pm 10\%$  (minimum 1 piece).

**Technical description**

Tolerance nominal Ø	h7
Flute length $L_c$	101 mm
Overall length L	153 mm
Shank Ø $D_s$	20 mm
Number of cutting edges Z	2
Standard	DIN 6537

Feed f in titanium > 850 N/mm <sup>2</sup>	0.2 mm/rev.
Ø range	18.06 - 20.05 mm
Coating	TiAlN
Tool material	Solid carbide
Version	6×D
Type	FS
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	pink
Type of product	Jobber drill

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	260 m/min	N
Aluminium (short chipping)	suitable	240 m/min	N
Alu > 10% Si	suitable	160 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	85 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	30 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	40 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	35 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	35 m/min	S

wet maximum	suitable
wet minimum	suitable
Air	suitable